

B/N incorrect Engaged on Dart Aerospace Ltd.

Saddles - S/B 27059 - File under
Process Sheet D2573 / 74

Date: Thursday, 5/11/2006 11:52:16 AM.
User: Kim Johnston

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)			
Job Number	: 27059	Part Number	: D2574			
Estimate Number	: 10534	Drawing Number	: D2574 REV E			
P.O. Number	: N/A	Project Number	: N/A			
This Issue	: 5/11/2006	S.O. No.	: N/A			
Prsh Rev.	: NC	Type	: MACHINED PARTS			
First Issue	: N/A	Material	: N/A			
Previous Run	: 26975	Due Date	: 5/30/2006			
Written By	See Comment Below					Qty: 16 Um: Each
Checked & Approved By	OB.05.11					
Comment	Est Rev: I As Per RevE 06-01-27 JLM					
Additional Product						
Job Number:						
Seq. #:	Machine Or Operation:	Description :				
1.0	D6101005	7075-T7351 8.25X5.0X2.5 				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u> </u> B 28940 x 16 En 1 J.G 06/07/02						
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 				
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>B27057</u> Double check by: <u>JL</u> P10 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. En 1 J.G 06/07/02						
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 				
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 <u> </u> En 1 J.G 06/07/02						
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 				
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u> </u> En 1 J.G 06/07/02						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/26	2.0	wrong Batch # Kept in. operator error 2 parts effected	<i>AB</i> <i>ABCD</i>	Change Batch # Right away tell operator to PAY more attention 2 parts Identical with B27059 D2574.	<i>AB</i> <i>AB</i>	<i>AB</i>	<i>AB</i>	<i>AB</i>

Part No: D2574 PAR #: P/A Fault Category: Press - CNC NCR: Yes No DQA: AB Date: 06.07.20
 NOTE: Date & initial all entries QA: N/C Closed: AB Date: 06.07.20

Date: Thursday, 5/11/2006 11:52:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 27059

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description : O

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

ML 06/07/04 16

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-07-04

(16)

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/18 (16)

DL

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PL 06/07/18 (16)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57352

PL 06/07/18 (16)

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PL 06.07.20

Job Completion:



W 06.07.19

NOTE: Date: 11/05/2011 AssurenceApp
H.100MS Quality Assurance App

Dart Aerospace
W/0

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD				Work Order:	27059
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.748	1.747	1.746	1.747		
C	3.495	3.505		3.499	3.497	3.497	3.498		
D	1.745	1.755		1.748	1.747	1.746	1.747		
E	7.990	8.010		8.006	8.006	8.007	8.003		
F	0.490	0.510		0.499	0.499	0.501	0.500		
G	0.257	0.262	DT8683	0.257	0.257	0.259	0.257		
H	0.375	0.380	DT8684	0.374	0.374	0.377	0.377		
I	0.490	0.510		0.498	0.496	0.495	0.494		
J	1.174	1.184		1.178	1.178	1.177	1.178		
K	0.558	0.578		0.561	0.565	0.565	0.568		
L	1.174	1.184		1.178	1.178	1.179	1.178		
M	1.365	1.375		1.367	1.369	1.366	1.367		
N	2.495	2.505		2.498	2.497	2.497	2.497		
O	4.119	4.129		4.123	4.119	4.122	4.121		
P	0.115	0.135		0.123	0.124	0.122	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.251	0.252		
S	0.115	0.135		0.119	0.118	0.120	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.235	0.240	0.237	0.239		
W	0.115	0.135		0.121	0.126	0.125	0.127		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.359	0.361	0.361	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.622	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.245	0.246	0.244		
AE	1.500	1.520		1.572	1.572	1.571	1.508		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.248	0.246	0.249		
AI	2.000	2.020		~19	~14	~14	~19		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP / J.G	Audited by:	JK
Date:	06/06/127	Date:	06/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK

DART AEROSPACE LTD	Work Order:	27059
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

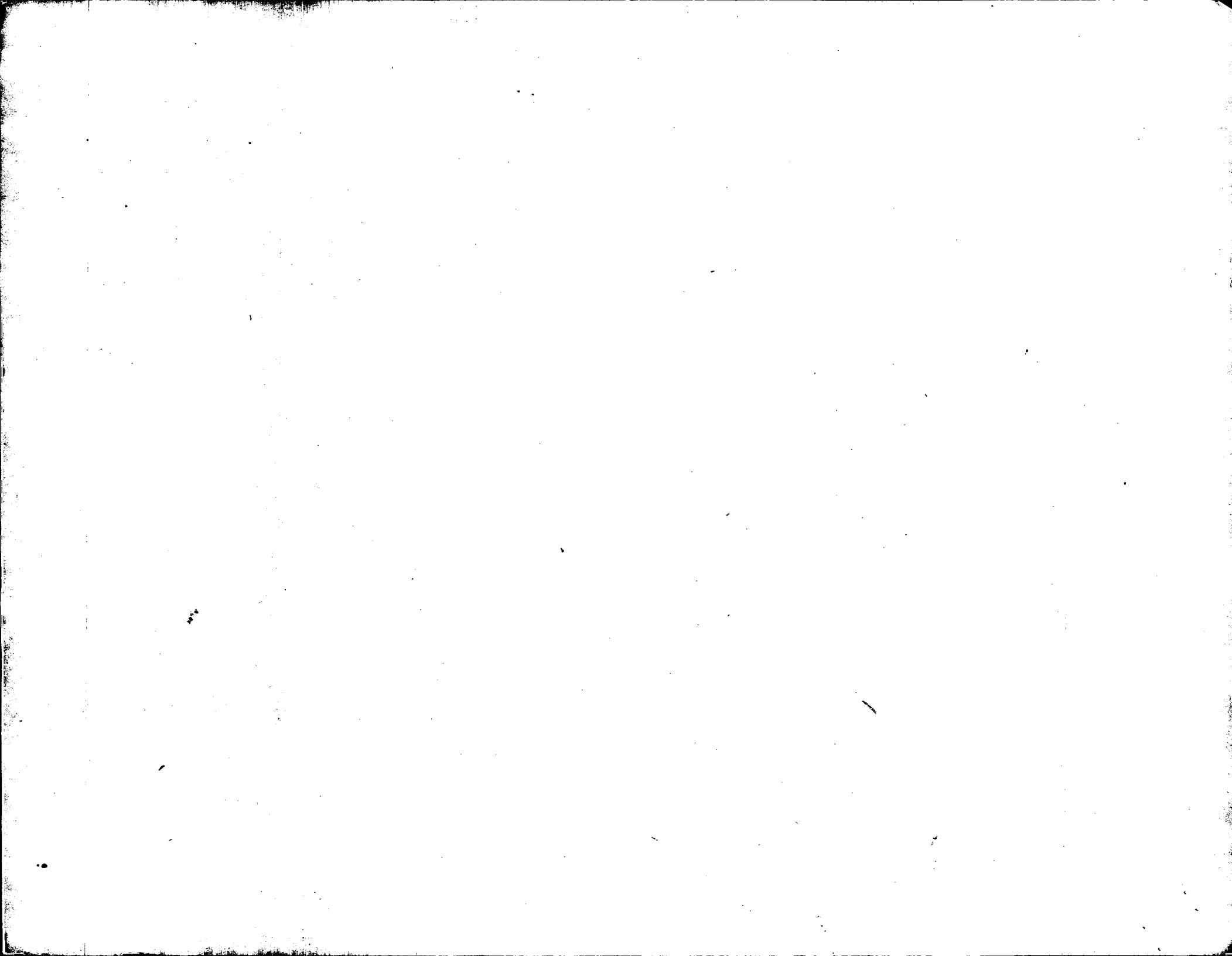
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					By	Date
				1	2	3	4			
A	0.438	0.443	DT8682	0.441	0.441	0.440	0.441			
B	1.745	1.755		1.747	1.747	1.750	1.748			
C	3.495	3.505		3.500	3.501	3.500	3.495			
D	1.745	1.755		1.748	1.747	1.750	1.748			
E	7.990	8.010		8.001	8.009	7.999	8.001			
F	0.490	0.510		0.499	0.498	0.498	0.498			
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259			
H	0.375	0.380	DT8684	0.357	0.374	0.377	0.377			
I	0.490	0.510		0.501	0.499	0.500	0.495			
J	1.174	1.184		1.177	1.177	1.179	1.177			
K	0.558	0.578		0.569	0.567	0.566	0.563			
L	1.174	1.184		1.177	1.178	1.179	1.177			
M	1.365	1.375		1.369	1.368	1.369	1.367			
N	2.495	2.505		2.499	2.498	2.499	2.499			
O	4.119	4.129		4.124	4.124	4.124	4.123			
P	0.115	0.135		0.129	0.128	0.121	0.123			
Q	0.115	0.135		0.135	0.135	0.135	0.135			
R	0.240	0.260		0.245	0.244	0.247	0.250			
S	0.115	0.135		0.130	0.129	0.121	0.121			
T	0.178	0.198		0.188	0.188	0.188	0.188			
U	3.210	3.250		3.230	3.230	3.230	3.230			
V	0.230	0.250		0.241	0.242	0.240	0.243			
W	0.115	0.135		0.124	0.125	0.127	0.130			
X	0.307	0.312		0.316	0.310	0.310	0.310			
Y	0.760	0.765		0.765	0.765	0.765	0.765			
Z	0.352	0.372		0.364	0.365	0.367	0.365			
AA	0.470	0.530		0.500	0.500	0.500	0.500			
AB	0.615	0.635		0.629	0.630	0.625	0.623			
AC	0.053	0.073		0.063	0.063	0.063	0.063			
AD	0.240	0.260		0.250	0.249	0.246	0.249			
AE	1.500	1.520		1.509	1.508	1.503	1.506			
AF	0.115	0.135		0.135	0.135	0.135	0.135			
AG	0.240	0.280		0.260	0.260	0.260	0.260			
AH	0.240	0.260		0.250	0.249	0.250	0.250			
AI	2.000	2.020		n/a	n/a	n/a	n/a			
AJ	0.023	0.043		0.030	0.030	0.030	0.030			

Accept/Reject

Measured by:	EP / J.G / J.L	Audited by:	JL
Date:	06/06/25	Date:	06/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JL



DART AEROSPACE LTD				Work Order:	Z7059
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.748	1.749	1.750	1.745		
C	3.495	3.505		3.497	3.496	3.496	3.500		
D	1.745	1.755		1.748	1.749	1.750	1.745		
E	7.990	8.010		8.001	8.001	8.001	8.003		
F	0.490	0.510		0.497	0.496	0.500	0.499		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.495	0.496	0.500		
J	1.174	1.184		1.177	1.178	1.176	1.178		
K	0.558	0.578		0.565	0.560	0.563	0.563		
L	1.174	1.184		1.177	1.178	1.176	1.178		
M	1.365	1.375		1.368	1.368	1.366	1.367		
N	2.495	2.505		2.499	2.495	2.498	2.495		
O	4.119	4.129		4.122	4.119	4.121	4.121		
P	0.115	0.135		0.122	0.122	0.121	0.121		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.257	0.250		
S	0.115	0.135		0.122	0.120	0.121	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.242	0.243	0.237	0.236		
W	0.115	0.135		0.123	0.127	0.127	0.123		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.355	0.364	0.362	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.625	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.249	0.250	0.244		
AE	1.500	1.520		1.507	1.508	1.511	1.509		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.253	0.247	0.247		
AI	2.000	2.020		n/a	n/a	n/a	n/a		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	En	Audited by:	JML
Date:	06/06/20	Date:	06/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JML

DART AEROSPACE LTD	Work Order:	27059
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.747	1.747	1.747	1.746		
C	3.495	3.505		3.497	3.497	3.497	3.497		
D	1.745	1.755		1.747	1.747	1.746	1.746		
E	7.990	8.010		7.999	7.999	7.998	7.999		
F	0.490	0.510		0.495	0.497	0.499	0.500		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.498	0.501	0.500		
J	1.174	1.184		1.177	1.177	1.178	1.177		
K	0.558	0.578		0.563	0.567	0.569	0.569		
L	1.174	1.184		1.177	1.178	1.179	1.180		
M	1.365	1.375		1.365	1.368	1.366	1.367		
N	2.495	2.505		2.495	2.497	2.499	2.497		
O	4.119	4.129		4.122	4.121	4.122	4.122		
P	0.115	0.135		0.123	0.124	0.125	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.248	0.247	0.247		
S	0.115	0.135		0.124	0.123	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.220	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.238	0.237	0.236		
W	0.115	0.135		0.125	0.124	0.123	0.125		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.766	0.765	0.765		
Z	0.352	0.372		0.359	0.360	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.620	0.621	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.246	0.247		
AE	1.500	1.520		1.501	1.508	1.508	1.507		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.258	0.249	0.251	0.249		
AI	2.000	2.020		nl	nl	nl	nl		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EO / J.G	Audited by:	JKL
Date:	06/07/02	Date:	06/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JKL

